I claim:

1. An arrangement for closing a through flow opening in a throttle valve connection piece of an internal combustion engine, comprising:

- a throttle valve shaft positioned over and transverse to said through flow opening, said shaft pivotably mounted to said throttle valve connection piece; and
- a throttle valve comprising a receiving opening running a length of and planar to said valve, said receiving opening comprising an interior opening wherein said shaft is mounted such that said valve selectively closes said flow opening, and one or more recesses into said interior opening wherein said valve is connected to said shaft by at least one welding.

2. The arrangement according to claim 1, wherein said valve comprises walls forming a hub, said hub comprising said receiving opening.

3. The arrangement according to claim 1 wherein said throttle valve comprises a connecting element connected to said throttle valve and projecting into said recess, said connecting element comprising a material weldable to said throttle valve shaft.

4. The arrangement according to claim 3, wherein said connecting element is welded to said throttle valve shaft at its projection within said recess.

5. The arrangement according to claim 4, wherein said connecting element projects tangentially with respect to the throttle valve shaft into said recess.

6. The arrangement according to claim 3, wherein said connecting element comprises two connecting elements arranged firmly connected to said throttle valve and projecting, in opposite directions to one another, tangential to said throttle valve shaft, and into said recess.

7. The arrangement according to claim 6, wherein said shaft further comprises opposing ends projecting into recesses within a housing of said throttle valve connection piece.

8. The arrangement according to claim 7, further comprising a plurality of shafts wherein facing shaft ends at least approximately contact one another.

9. The arrangement according to claim 3, wherein said connecting element extends, along said valve shaft, an a substantial length of said recess.

10. The arrangement according to claim 3, further comprising a plurality of connecting elements adjacently arranged within said recess and along said throttle valve shaft.

11. The arrangement according to claim 3, wherein:

- said valve comprises an injection molded material, and
- said connecting element is firmly connected to said throttle valve as an insertion part by encapsulation by injection molding using the material of the throttle valve during its manufacture.

12. The arrangement according to claim 11, wherein said connecting element is an insertion plate.

13. The arrangement according to claim 9, wherein said throttle valve comprises a lightweight metal.

14. The arrangement according to claim 9, wherein said throttle valve comprises a plastic used in injection molding.

15. The arrangement according to claim 1, wherein said throttle valve shaft comprises steel.

13. The arrangement according to claim 1, wherein said an end of said connecting element abuts said throttle valve shaft with prestress.

14. The arrangement according to claim 1, wherein said at least one welding is a fused welded connection generated by resistance welding or laser welding.

15. The arrangement according to claim 1, wherein said at least one welding comprises a welding seam.

16. The arrangement according to claim 1, wherein said at least one welding comprises one or more welding points.

17. The arrangement according to claim 1, wherein said at least one welding comprises at least one spot welding.

18. The arrangement according to claim 1, wherein said at least one welding comprises a continuous welding.